

Work Order ID 144180

Wednesday, April 06, 2016 8:22:08 AM

144180

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Item ID: E4736-049

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Service Deck Drain Line Assembly

Start Date: 4/6/2016

Start Qty: 11.00

11

Cust Item ID:

Required Date: 4/28/2016

Req'd Qty: 11.00

11

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

E4736

A

121

0.00

121

Small Fab

Small Fab

Memo

PULL FROM W/O 139994 - E4736-3
CUT TO SIZE TO MAKE E4736-049
PARTS ON 139994 WERE CUT TOO SHORT.

CUT AND FLARE AS PER DWG
INSTALL NUTS BEFORE FLARING*

0.00

122

QC5- Inspect part completeness to step on W/O

0.00

122

QC

Quality Control

Memo

0.00

Handwritten: CANCEL
w
7-06-20

Handwritten: use

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Item ID: E4736-049 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Service Deck Drain Line Assembly
Start Date: 4/6/2016 Start Qty: 11.00 ***11*** Cust Item ID:
Required Date: 4/28/2016 Req'd Qty: 11.00 ***11*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

U 17.06.21

Picklist Print

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Wednesday, April 06, 2016 8:23:03 AM

Work Order ID: 144180

144180

Parent Item: E4736-049

F4736-049

Parent Item Name: Service Deck Drain Line Assembly

Start Date: 4/6/2016

Required Date: 4/28/2016

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN818-10D		Purchased	No				Each	35.0000		11			
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AN818-10D

Nut Coupling

Location

Loc Qty

Loc Code

ST325

35

121978

1

122459

10

m134606

24

E4736-3

Manufactured

No

Each

0.0000

6

F4736-3

Tube

MS20819-10J

Purchased

No

Each

9.0000

11

MS20819-10J

sleeve

Location

Loc Qty

Loc Code

ST305

9

123561

9

m122814 (5x)

m134606 (6x)

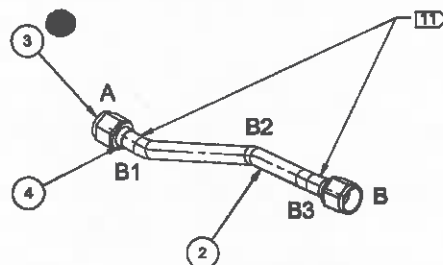
Acceptable for Engineering to
Change from Stainless Steel (J) to
Aluminum (D).



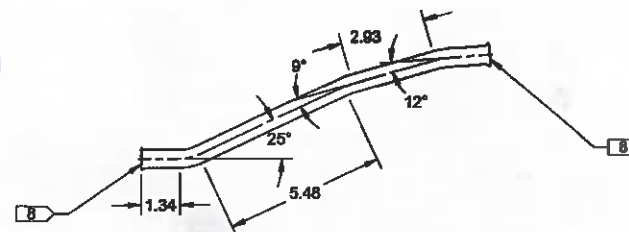
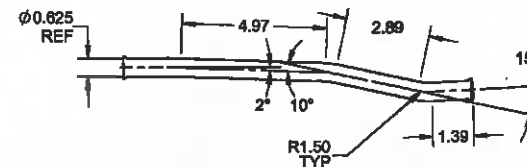
2017.0206

ITEM NO.	QTY -049	PART NUMBER	DESCRIPTION
1	X	E4736-049	DRAIN LINE ASSEMBLY
2	1	E4736-8	TUBE
3	2	AN818-10D	NUT COUPLING
4	2	MS20819-10J	SLEEVE COUPLING

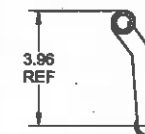
BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	1.28	25.0°	0.0°
2	1.50	5.38	18.0°	278.0°
3	1.80	11.52	30.0°	150.0°
END B - TL	-	13.46	-	-



E4736-049 SERVICE DECK DRAIN LINE ASSEMBLY



E4736-8 TUBE



NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, Ø0.825 X 0.035 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/6 OR QQ-A-225/6
REF DART SPEC M6061T4T0.625W.035
OR
5052-O ALUMINUM ROUND TUBING, Ø0.825 X 0.035 WALL
PER AMS-WW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-O10.625W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 200 PSI
- 10) MARK LINE WITH BRADY 8-999 "DRAIN" TAPE IN LOCATIONS SHOWN

DESIGN		EAGLE COPTERS LTD	
DRAWN	<i>[Signature]</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. E4736	REV. A
MFG. APPR.	N/A		SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE DRAIN LINE	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	12.11.01	COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.	

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